

# Work Order ID 72211

Wednesday, July 20, 2011 7:53:28 AM



Page 1

Item ID: D3453-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 11-07-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan / Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3453

Rev A

*Handwritten: B 11.08.10*

100

0.00



Doosan

Doosan Lathe

Memo

1-Turn as per Folio FA577

Rev: *Handwritten: 11*

Dwg D3453 Rev: *Handwritten: 13*

2- Deburr as per dwg D3453

0.00

*Handwritten: 11.8.9*

*Handwritten: 6*

150

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

*Handwritten: 11.8.7*

*Handwritten: 6*

160

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

*Handwritten: 11/8/9*

*Handwritten: 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72211**

Wednesday, July 20, 2011 7:53:28 AM

Page 2

Item ID: D3453-1

Accept

Revision ID:

Item Name: Clevis

Start Date: 7/19/2011 Start Qty: 6.00

Required Date: 7/26/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/10  
(6)

11/08/10  
(6)

11-08-10  
(6)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 20, 2011 7:53:52 AM

Page 1

Work Order ID: 72211

Parent Item: D3453-1

Parent Item Name: Clevis



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: A ☐ 05.09.27 ☐ New issue ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R1.250

Purchased

No

100

f

44.8900

0.288

1.728



304 round bar 1.250



20 11.8.9

Location

Loc Qty

Loc Code

MAT029

44.89

105872

12.33

108156 ✓

11.33

111018

21.23

1.750

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 72247
<b>Description:</b> Clevis		<b>Part Number:</b> D3453-1
<b>Inspection Dwg:</b> D3453 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.440	/		RR.02	
R0.25	+/-0.030	2.250	/			
0.450	+/-0.010	.450	/			
0.625	+/-0.010	.627	/			
0.063 x 45°	+/-0.010 x 0.5°	.060 x 45	/			
Ø0.129	+0.005/-0.001	.128	/		"	
3.26	+/-0.030	3.259	/			
1.00	+/-0.030	.997	/			
1.550	+/-0.010	1.551	/			
0.500	+0.010/-0.000	.503	/			
0.263 x 45°	+/-0.010 x 0.5°	.264	/			
R0.25	+/-0.010	2.25	/		"	
Ø1.13	+0.012/-0.001	1.127	/			
Ø0.500	+0.000/-0.005	.497	/		"	

<b>Measured by:</b> RR	<b>Audited by:</b> SJ	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-8-9	<b>Date:</b> 11/8/9	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	
C	08.10.09	Diameter symbol removed from 0.500 dimension	KJ/DD	
D	09.11.04	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

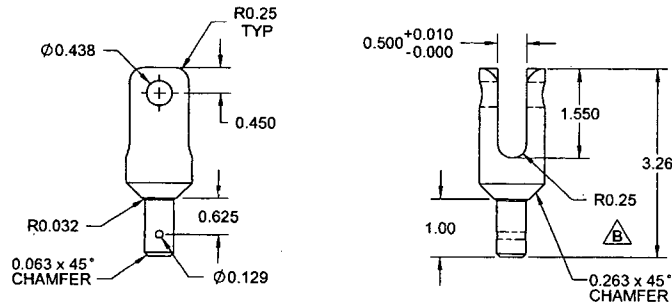
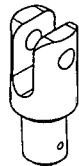
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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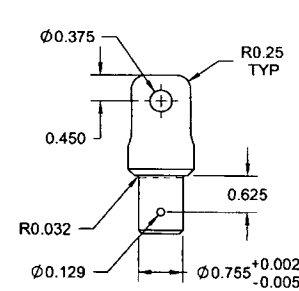
**NOTE:** Date & initial all entries



SHOP COPY  
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 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 72211 *PL 11-07-20*



**D3453-1 CLEVIS**



**D3453-3 CLEVIS**

- D3453-1/-3 NOTES:**  
 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: D3453-1 = 0.41 lbs  
 D3453-3 = 0.41 lbs

**RELEASED**  
*5/16/25*

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018	RF	09.05.21
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3453</b> TITLE <b>CLEVIS</b> SCALE <b>NTS</b>	
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. B SHEET 1 OF 2	
DATE	09.05.21		

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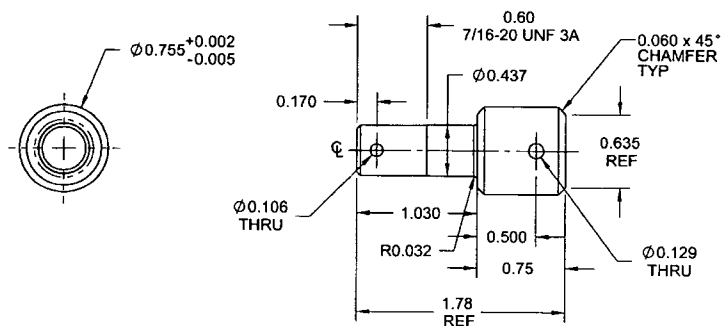
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:**\*Date & initial all entries



**D3453-5 PLUG**

**D3453-5 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

**RELEASED**  
09/05/21

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	WJ	<b>D3453</b>	SHEET 2 OF 2
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	<b>CLEVIS</b>	NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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